

Date: Wednesday, 7/5/2006 2:48:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 27815A		Part Number	: D2221		
Estimate Number	: 10189		Drawing Number	: D2221/D2235		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/5/2006		Drawing Revision	: F/B1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: / /		Due Date	: 7/30/2006		
Previous Run	: 27578A		Qty:	1 Um: Each		
Written By	: <u>See Company Below</u>					
Checked & Approved By	: <u>06.07.05</u>					
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31661	Basket Hoop		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D3166-1 RIB <u>Bab717</u>	<u>PD</u>	<u>06.07.07</u>
2.0	D22323	Basket Hinge		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2232-3 Hinge bracket <u>B24527</u>	<u>PD</u>	<u>06.07.07</u>
3.0	D2325	Support Gusset (350 Bask)		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D2325 Support Gusset <u>Bab741</u>	<u>PD</u>	<u>06.07.07</u>
4.0	D23273	Spacer Bushing		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2327-3 Bushing <u>B27051</u>	<u>PD</u>	<u>06.07.07</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B27524

PD

06-07-07

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B26739

PD

06-07-07

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal H101358

PD

06-07-07

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: H101309

PD

06-07-07

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/08/14
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27815A

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

AD 06/07/24 ①

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25 ①

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/10 ①

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M101621.

Expiry date: 02/2007

m.f. 06/08/10

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/08/14

Job Completion



CY06/08/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

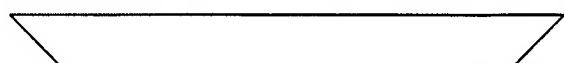
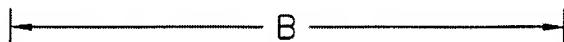
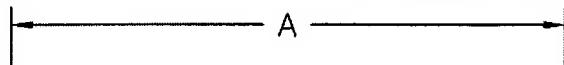
RELEASED

05.08.19 *AA*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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WITHOUT NOTICE
45° WORK ORDER
NO. 27815A

D2221-1/-3/-5/-7

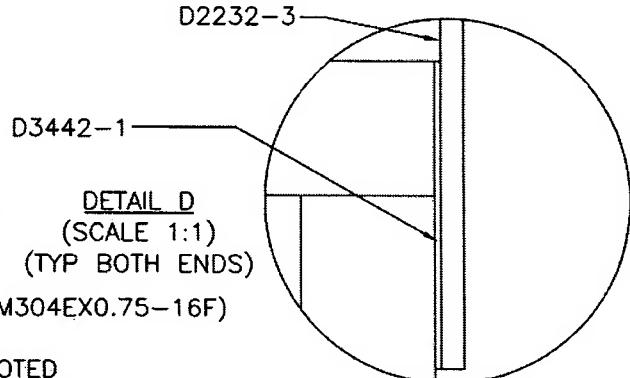
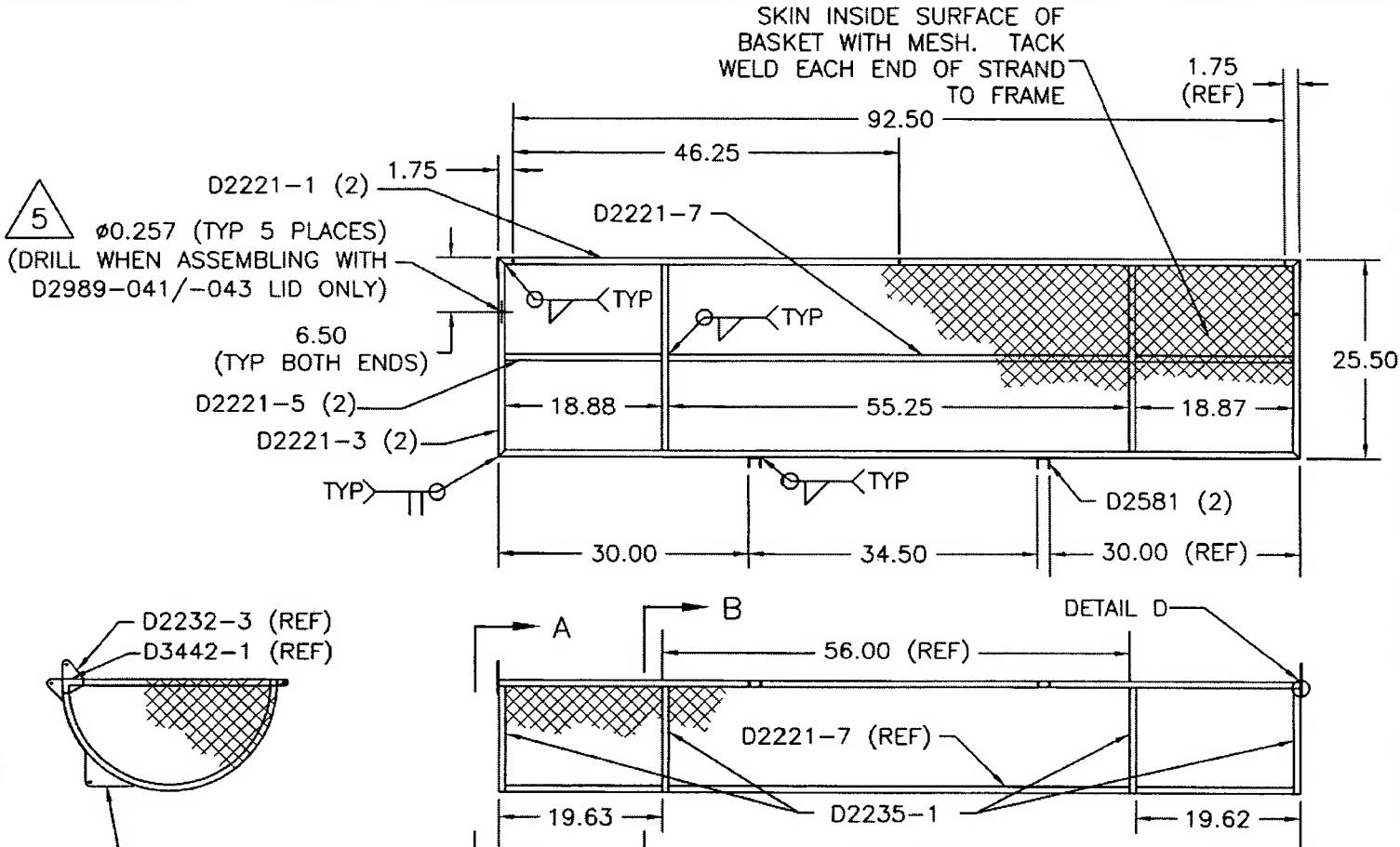
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2221	HAWKESBURY, ONTARIO, CANADA REV. F
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3 SCALE 1:20

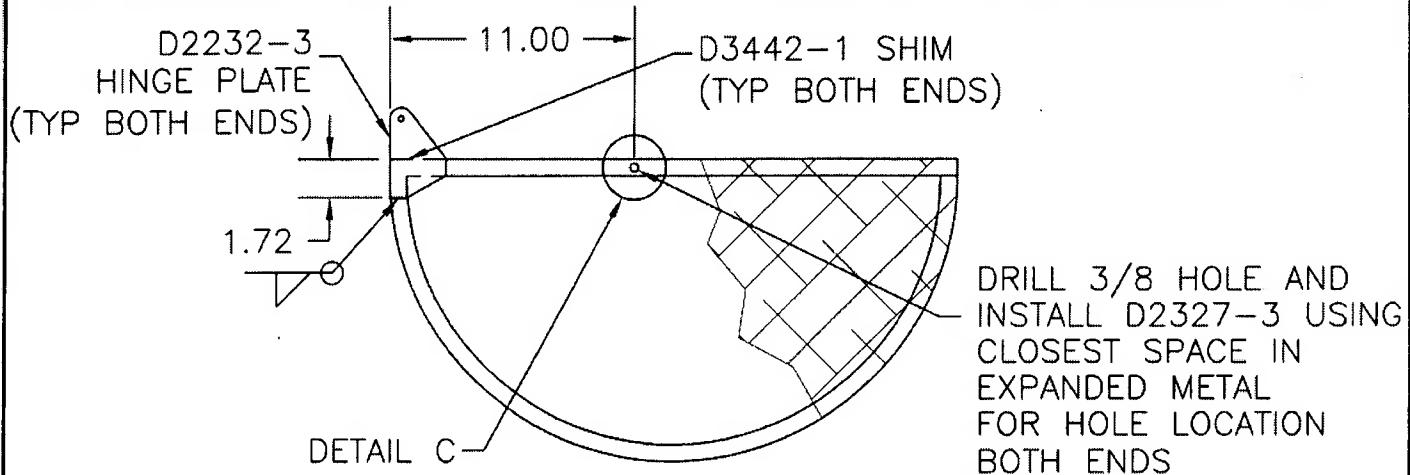
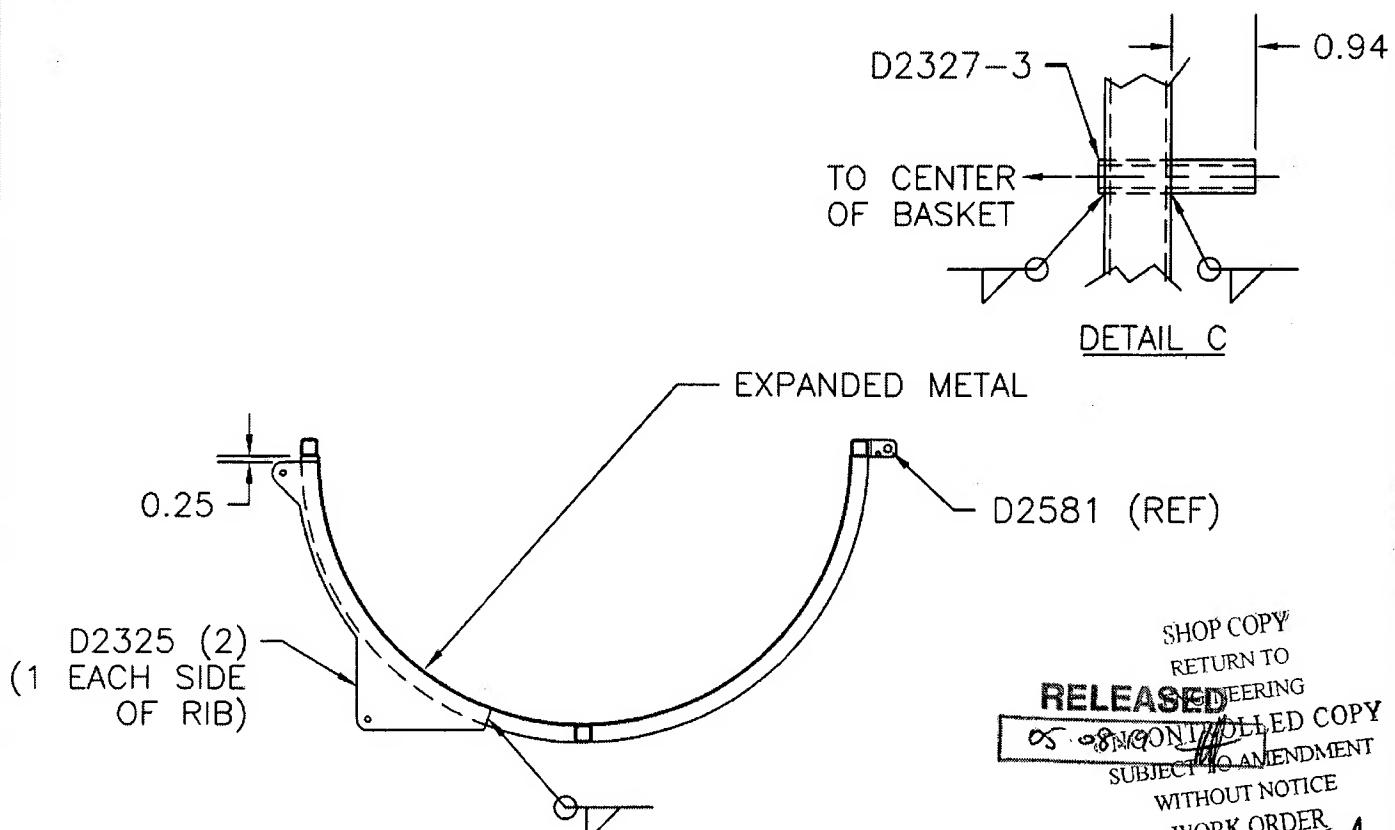


D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

DESIGN	BW	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	<i>AA</i>	APPROVED	<i>AA</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.07	DRAWING NO.	D2221	REV. F SHEET 3 OF 3
		TITLE	BASKET BASE ASSEMBLY (350)	SCALE 1:8

SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

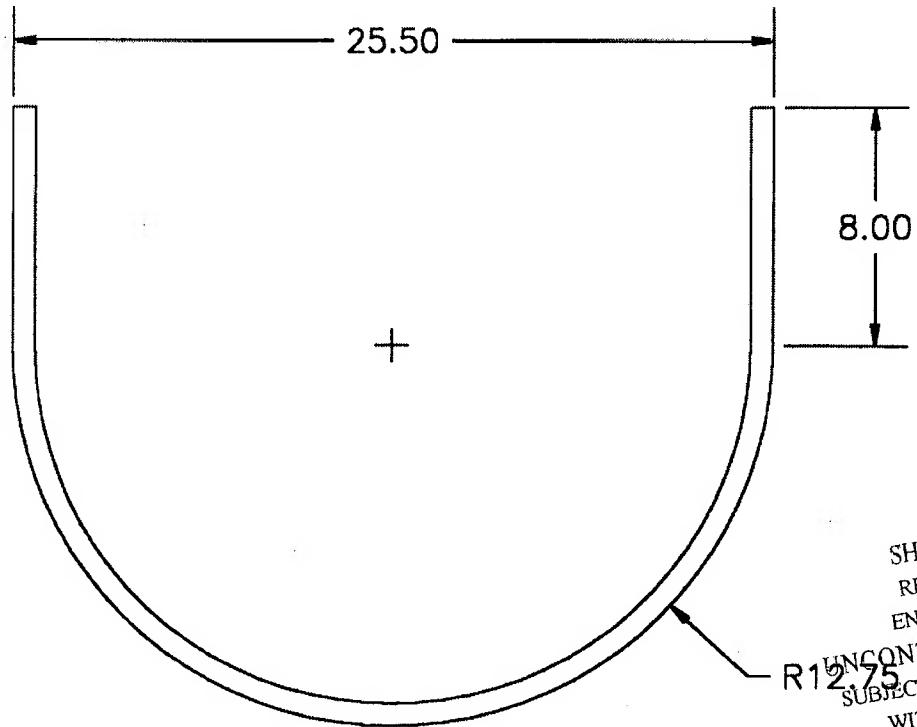
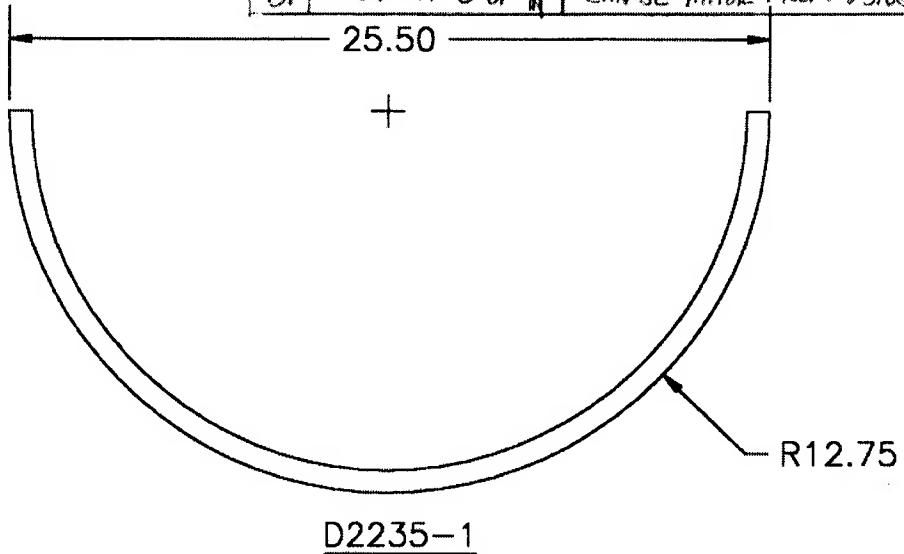
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DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>SW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		TITLE SCALE BASKET RIBS

BI 02.08.06 *U/H* CAN BE MADE FROM D3166-1**RELEASED**
R 960507CAN BE MADE FROM D3166-1 BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.